

December 16, 2015 11:52:56 AM

**Item ID:** E4733-1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Bracket

Stop \*NS2\*

**Start Date:** 12/16/2015      **Start Qty:** 6.00

**\*6\***

**Cust Item ID:**

**Required Date:** 3/1/2016      **Req'd Qty:** 6.00

**\*6\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|                 |                     |
|-----------------|---------------------|
| <b>Draw Nbr</b> | <b>Revision Nbr</b> |
| E4733           | A 11                |

100

0.00

**\*100\***

## FLOW WATER JET

## Waterjet

## Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg E4733-1

Dwg Rev: **A**

Prog Rev: **A**

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

**Work Order ID 139989****\*139989\***

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Item ID: E4733-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 12/16/2015 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 3/1/2016 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID               | Operation<br>Description                                  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code      | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                   |
|----------------------------------------------|-----------------------------------------------------------|----------------------|---------|--------|-------------------|---------------|---------------|------------------|----------------------------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control | QC8- Inspect parts - second check<br><br>Memo             | 0.00<br><br>0.00     |         |        |                   | <u>6</u>      |               |                  | DAS<br>38<br>9-89<br>MAR 01 2016 |
| 132<br><b>*132*</b><br>Brake NC<br>Brake NC  | Bend as per dwg<br><br>Memo                               | 0.00<br><br>0.00     |         |        | DAS<br>30<br>9-89 | <u>6</u>      |               |                  | MAR 14 2016                      |
| 150<br><b>*150*</b><br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br><br>0.00     |         |        |                   | <u>6</u>      |               |                  | DAS<br>38<br>9-89<br>MAR 14 2016 |

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Item ID: E4733-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 12/16/2015      Start Qty: 6.00      **\*6\***      Cust Item ID:  
Required Date: 3/1/2016      Req'd Qty: 6.00      **\*6\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description                                   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                   |
|-----------------------------------------------------|------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------------|
| 160<br><b>*160*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo        | 0.00<br><br>0.00     |         |        |              | 6             |               | 16-3-15          |                                  |
| 161<br><b>*161*</b><br>QC<br>Quality Control        | QC7-Inspect Chemical Conversion Coat<br><br>Memo           | 0.00<br><br>0.00     |         |        |              | 6             |               |                  | DAS<br>38<br>9-89<br>MAR 16 2016 |
| 180<br><b>*180*</b><br>Packaging<br>Packaging       | Identify as per dwg & Stock Location: <u>5</u><br><br>Memo | 0.00<br><br>0.00     |         |        |              | 6             |               |                  | DAS<br>6<br>9-89<br>MAR 16 2016  |

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Item ID: E4733-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 12/16/2015 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 3/1/2016 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*190*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

*mcj* MAR 21 2016

*mcj* MAR 16 2016

# Picklist Print

December 16, 2015 11:53:00 AM

Page 1

Work Order ID: 139989

**\*139989\***

Parent Item: E4733-1

**\*F4733-1\***

Parent Item Name: Bracket

Start Date: 12/16/2015

Required Date: 3/1/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6S.050

Purchased

No

sf

174.3000

0.701684

**\*M6061T6S 050\***

6061-T6 .050 Sheet

**\*\***

02/16/02/27

Location

Loc Qty

Loc Code

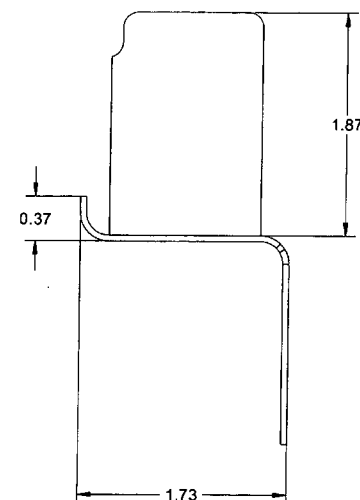
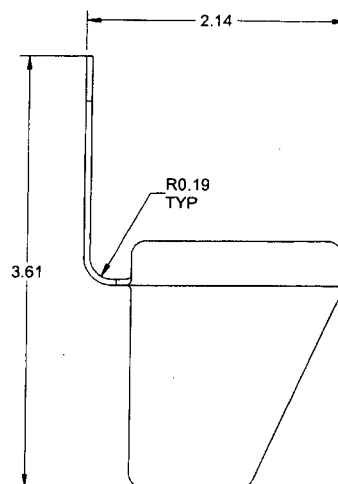
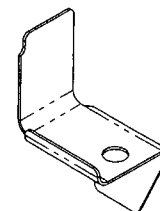
MAT021

174.3

m131352

174.3

.7



**E4733-1 BRACKET**

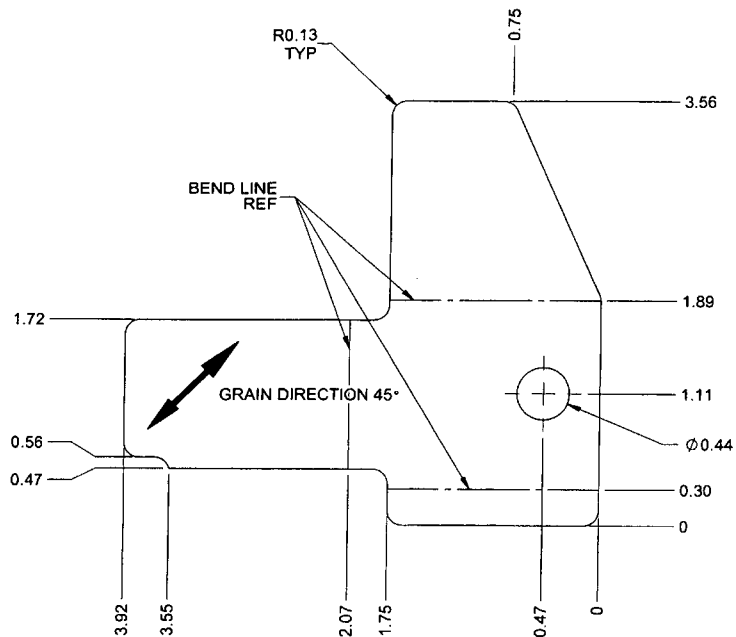
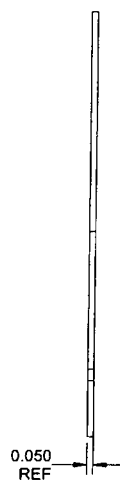
**RELEASED**  
2013-11-28

20151217

44 139989

- NOTES:**
- 1) MATERIAL: MADE FROM E4733-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.04 lbs

|            |             |                                                                                                                                                                                                                                                                                       |              |
|------------|-------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE   | DC                                                                                                                                                                                                                                                                                    | 12.12.12     |
| REV.       | DESCRIPTION | BY                                                                                                                                                                                                                                                                                    | DATE         |
| DESIGN     | DC          | <b>EAGLE COPTERS LTD</b><br>CALGARY, ALBERTA, CANADA                                                                                                                                                                                                                                  |              |
| DRAWN      | DC          |                                                                                                                                                                                                                                                                                       |              |
| CHECKED    | DC          | DRAWING NO.                                                                                                                                                                                                                                                                           | REV. A       |
| MFG. APPR. | DC          | E4733                                                                                                                                                                                                                                                                                 | SHEET 1 OF 6 |
| APPROVED   | DC          | TITLE                                                                                                                                                                                                                                                                                 | SCALE        |
| DE APPR.   | DC          | BRACKET                                                                                                                                                                                                                                                                               | NTS          |
| DATE       | 12.12.12    | COPYRIGHT © 2012 BY EAGLE COPTERS LTD<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.</small> |              |



**E4733-1F FLAT PATTERN**

**RELEASED**  
2013-11-28

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.050 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

|                                                                                                                                                                                                                               |          |                                       |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                        | DC       | <b>EAGLE COPTERS LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                         | DC       | CALGARY, ALBERTA, CANADA              |              |
| CHECKED                                                                                                                                                                                                                       | DC       | DRAWING NO.                           | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                    | DC       | <b>E4733</b>                          | SHEET 2 OF 6 |
| APPROVED                                                                                                                                                                                                                      | DC       | TITLE                                 | SCALE        |
| DE APPR.                                                                                                                                                                                                                      | DC       | <b>BRACKET</b>                        | NTS          |
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